

Amendments to the Specification

Please replace paragraph [0001] on page 1 with the following amended paragraph:

[0001] This application is a continuation-in-part of an application entitled " Method and Apparatus for Injection Molding Articles ", application serial number 09/900,083 filed July 6, 2001, now abandoned, and is incorporated herein by reference.

Please replace paragraph [0012] on page 1 with the following amended paragraph:

[0012] Also, since the valve stem 18 is surrounded by molten material, it becomes quite hot. When the gate is closed by the valve stem 18, the hot tip of the valve stem 18 cools slower than the gate insert 31 as the mold cavity 28 is cooled. Ideally, molded article 27 is not removed ~~from~~ from the mold until the vestige 26 has cooled sufficiently to allow a clean separation of the solidified material at the face portion 21 of the valve stem 18. With the valve stem being hot compared to the gate insert, this can require increased cycle times to permit the necessary cooling and/or can result in undesirable characteristics in the molded article 27. Specifically, as the material in the mold cavity 28 adjacent the valve stem 18 is cooled relatively slowly due to the hot valve stem 18, parts molded from thermally sensitive materials, such as PET, can suffer from an enlarged area of crystallinity 40 or other undesired characteristics. To reduce cycle times, a mold may be opened before the material adjacent the face portion 21 has sufficiently solidified. Since the entire top surface of the vestige 26 is in contact with the face portion 21 of the hot valve stem 18, stringing and an uneven edge may form when the mold is opened.